

Work Order ID 58484

May 7, 2010 1:28:42 PM



Page 1

Item ID: D4021-7

Accept



Setup Start



Revision ID:

Item Name: Hoop

Stop



Start Date: 07/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Waterjet

Memo

0.00

Handwritten: 10-5-10

FLOW CNC Waterjet

Cut as per dwg D4021

Prog Rev: *Handwritten: 5*

Dwg Rev: *Handwritten: B*

Deburr as required

Handwritten: 10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Handwritten: 10-5-10

Quality Control

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

8/05/10

46

130

Small Fab

Small Fab

Memo

1- make radius as per dwg
2- deburr

0.00

0.00

=> m.k 10/05/12

64

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/05/12

46

W/O:			WORK ORDER CHANGES					
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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

Memo

0.00

6 8

PL 10-05-17

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/17

PL 10-5-17
(4)

W/O:			WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 58484



Parent Item: D4021-7



Parent Item Name: Hoop

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg REV.A DD 10.02.22 verified by:EC
DD 10.04.20 verified by:EC

IPP Rev:B as
IPP Rev:C as per dwg revB

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
M304B0.625X3.000		Purchased	No			100	f	5.7147	0.4166			
304 BAR .625 X 3.00												



R10-5-10

Location

Loc Qty

Loc Code

MAT53

5.7147

112320

5.7147

112320

6

W/O:			WORK ORDER CHANGES					
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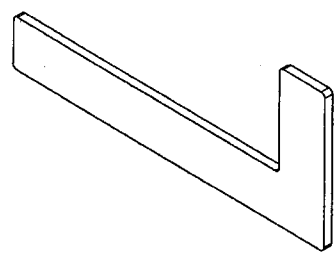
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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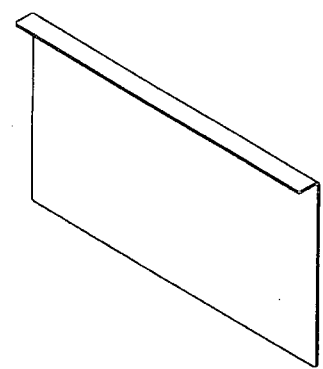
NOTE: Date & initial all entries

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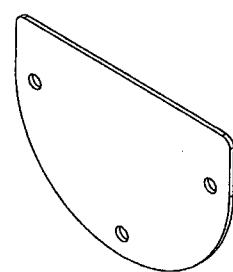
D
C
B
A



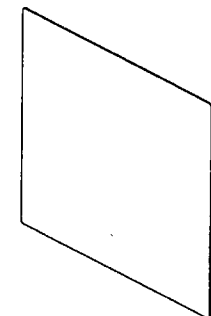
D4021-1 HANDLE PLATE



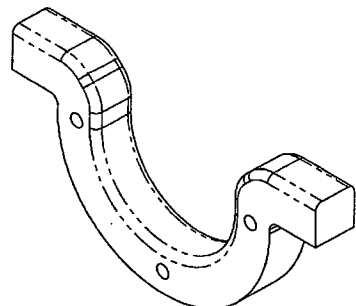
D4021-3 DATA PLATE



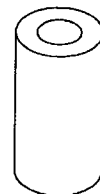
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58484

2010-5-07

RELEASED
2010-04-14
MP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4021	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

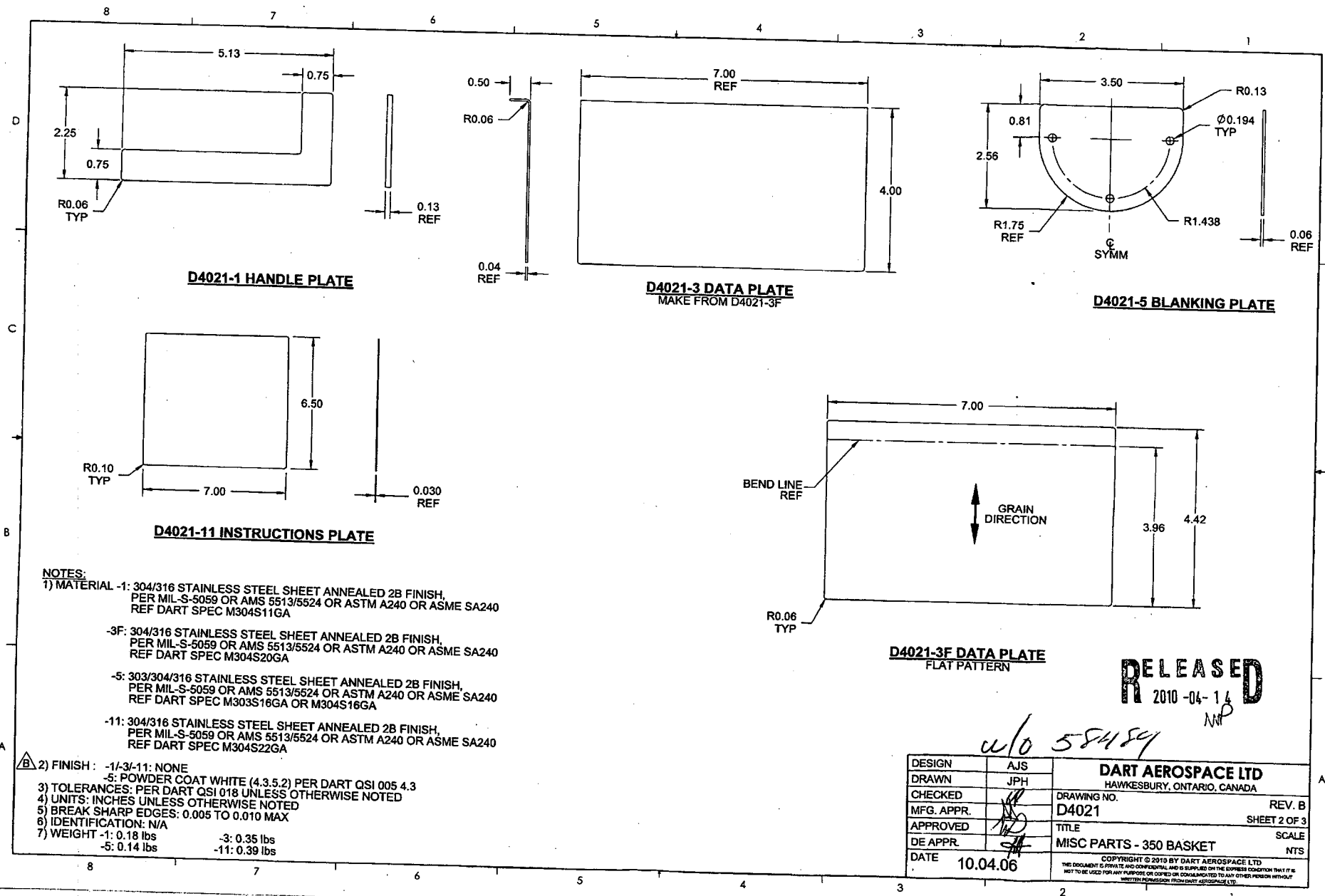
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RELEASED
R 2010-04-14
NIP

u/o 58484

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. REV. B
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		MISC PARTS - 350 BASKET NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

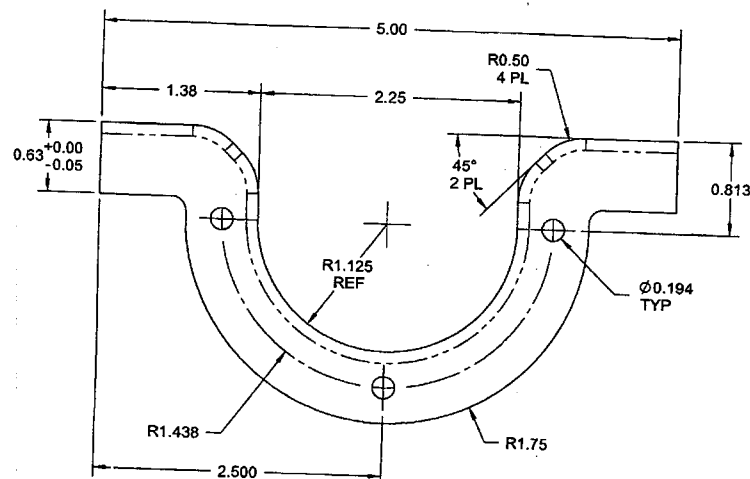
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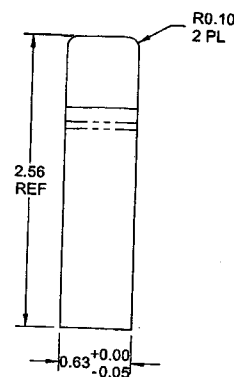
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D4021-7 HOOP



D4021-9 BUSHING

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

WLO 58484

RELEASED
2010-04-14
NR

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
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